

Date: Wednesday, 07/01/2009 1:36:54 PM  
 User: Julie Dawson

## Process Sheet

|                       |  |  |              |                  |              |  |
|-----------------------|--|--|--------------|------------------|--------------|--|
| Customer              | : CU-DAR001 Dart Helicopters Services                  |  | Drawing Name | : STA 84 BRACKET |              |  |
| Job Number            | : 44477  |  |              |                  |              |  |
| Estimate Number       | : 11034  |  |              |                  |              |  |
| P.O. Number           | :  |  |              | Part Number      | : D28031     |  |
| This Issue            | : 07/01/2009   |  | S.O. No.     | : D2803 REV B    |              |  |
| Prsht Rev.            | : NC   |  |              | Project Number   | : N/A        |  |
| First Issue           | : / /  |  | Type         | : MACHINED PARTS |              |  |
| Previous Run          | : 41738  |  |              | Drawing Revision | : B          |  |
| Written By            | :  |  |              | Material         | :            |  |
| Checked & Approved By | : <u>JULIE DAWSON</u>                                  |  |              | Due Date         | : 30/01/2009 |  |
| Comment               | : Est. A00.11.06 New Issue EC                          |  |              | Qty:             | 4 Um: Each   |  |
|                       | Est Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM      |  |              |                  |              |  |
|                       | Est Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC |  |              |                  |              |  |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation:   | Description :                          |  |
|---------|---|--|--|
| 1.0     | M6061T6B0500X10000  | 6061-T6 Bar .500 x 10.00               |  |
|         |   |  |  |
|         | Comment: Qty.: 2.0125 f(s)/Unit Total : 8.0501 f(s)<br>6061-T6 Bar .50" x 10.0"<br>Material: 6061-T6 bar 10.00" x 0.50" | 105411X<br>Batch: 109288 13 9-1-12     |  |
| 2.0     | WATER JET   | FLOW WATER JET                         |  |
|         | Comment: FLOW WATER JET<br>1-Cut as per template DT8533<br>Dwg Rev: <u>B</u> 13 9-1-12<br>Prog Rev: <u>B</u>            |  |  |
|         | 2-Deburr if necessary   |  |  |
| 3.0     | HAAS1   | HAAS CNC VERTICAL MACHINING #1         |  |
|         | Comment: HAAS CNC VERTICAL MACHINING #1<br>Machine as per folio FA102   | mw= 08/01/17                           |  |
| 4.0     | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE |  |
|         | Comment: INSPECT PARTS AS THEY COME OFF MACHINE   | mw= 08/01/17                           |  |
| 5.0     | QC8   | SECOND CHECK                           |  |
|         | Comment: SECOND CHECK   | SP 09/01/20                            |  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D2803-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: JH Date: 09-01-24  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 09-01-28

| NCR: 44477 |      | WORK ORDER NON-CONFORMANCE (NCR)  |                                  |   |                         |                           |                                  |                          |
|------------|------|---|----------------------------------|---|-------------------------|---------------------------|----------------------------------|--------------------------|
| DATE       | STEP | Description of NC<br>Section A  | Corrective Action Section B      |   |                         | Verification<br>Section C | Approval<br>Chief Eng            | Approval<br>QC Inspector |
|            |      |   | Initial<br>Chief Eng             | Action Description<br>Chief Eng                     | Sign &<br>Date          |                           |                                  |                          |
| 09/01/17   | 3.0  | All hole not drill at right place because Z origin was not well taken Human error   | GP<br>09.01.17<br>par<br>QSI 042 | Scrap and destroy<br>and Replace QHx1<br>B# B105411 | mmw= 09/01/17           | S 09/01/19                | GP<br>09.01.19<br>par<br>QSI 042 | S 09/01/19               |
| 09/01/17   | 3.0  | Thickness measure .125 ± .010 is too small due to stock material too small (.482 need .500) and Z origin is taken from top of blank | GP<br>09.01.17<br>par<br>QSI 042 | SCRAP & DESTROY<br>No Replace<br>QHx ④              | mmw 09/01/17<br>B105411 | S 09/01/19                | GP<br>09.01.19<br>par<br>QSI 042 | S 09/01/19               |
|            |      | Measure 0.109" Z<br>bcz No offset was taken to achieve proper thickness operator error.   |                                  |   |                         |                           |                                  |                          |

NOTE: Date &amp; initial all entries



| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                       |        |              |             |
|-----------------------|--------|--------------|-------------|
| DART AEROSPACE LTD    |        | Work Order:  | 44477       |
| Description: Bracket  |        | Part Number: | D2803-1     |
| Inspection Dwg: D2803 | Rev: B |              | Page 1 of 1 |

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.757            | +0.005/-0.000 | Ø .757           | ✓      |        |                      |          |
| Ø0.191            | +0.005/-0.000 | Ø .191           | ✓      |        |                      |          |
| Ø0.507            | +0.000/-0.001 | Ø .507           | ✓      |        |                      |          |
| 13.558            | +/-0.010      | 13.556           | ✓      |        |                      |          |
| Ø0.507            | +0.000/-0.001 | Ø .506           | ✓      |        |                      |          |
| 12.411            | +/-0.010      | 12.410           | ✓      |        |                      |          |
| 2.654             | +0.000/-0.001 | 2.654            | ✓      |        |                      |          |
| 0.437             | +0.000/-0.001 | .437             | ✓      |        |                      |          |
| 1.420             | +/-0.001      | 1.420            | ✓      |        |                      |          |
| 6.933             | +/-0.010      | 6.933            | ✓      |        |                      |          |
| 0.250             | +/-0.010      | .250             | ✓      |        |                      |          |
| 0.875             | +0.000/-0.001 | .875             | ✓      |        |                      |          |
| 0.250             | +0.000/-0.005 | .250             | ✓      |        |                      |          |
| 0.125             | +/-0.010      | .126             | ✓      |        |                      |          |
| 0.125             | +/-0.010      | .115             | ~      |        |                      |          |
| 0.125             | +/-0.010      | .116             | ✓      |        |                      |          |
| 0.125             | +/-0.010      | .117             | ✓      |        |                      |          |
| 0.500             | +/-0.010      | .499             | ✓      |        |                      |          |
| 0.562             | +/-0.010      | .562             | ✓      |        |                      |          |
| 0.188             | +/-0.010      | .188             | ✓      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|              |          |
|--------------|----------|
| Measured by: | mwp      |
| Date:        | 09/01/17 |

|             |          |
|-------------|----------|
| Audited by: | 88       |
| Date:       | 09/01/20 |

|                     |     |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date:               | N/A |

| Rev | Date     | Change                   | Revised by | Approved |
|-----|----------|--------------------------|------------|----------|
| A   | 05.04.25 | New Issue                | KJ/JLM     |          |
| B   | 07.07.18 | 12.625 dimension removed | KJ/JLM     | EE       |

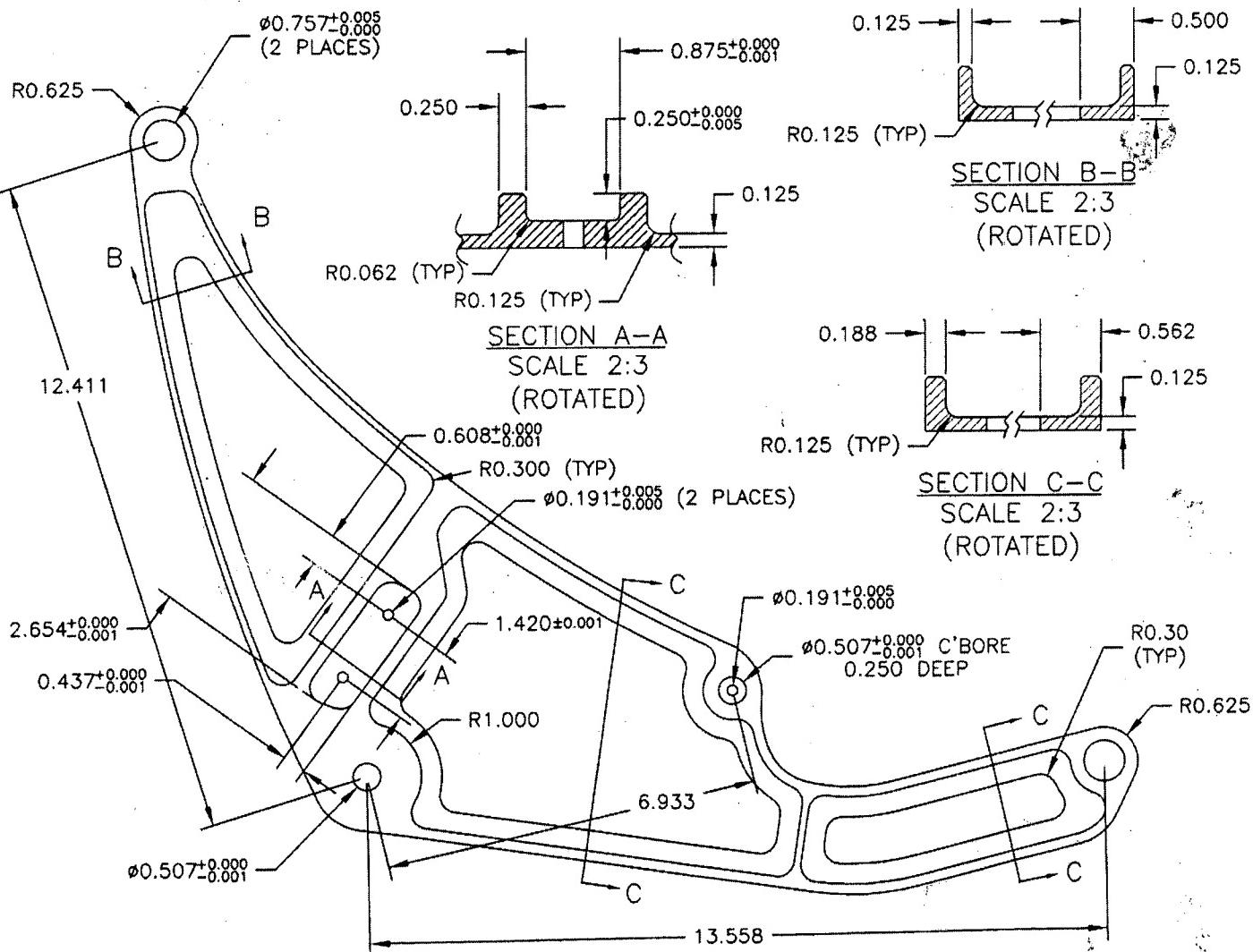


|                  |                         |   |                        |  |
|------------------|-------------------------|---|------------------------|--|
| DESIGN<br>CP     | DRAWN BY<br>CP          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |  |
| CHECKED<br>      | APPROVED<br>            | DRAWING NO.<br>D2803                              | REV. B<br>SHEET 1 OF 2 |  |
| DATE<br>04.11.22 | TITLE<br>STA 84 BRACKET |   | SCALE<br>1:3           |  |

RELEASED

05.03.11 -

|   |          |                         |
|---|----------|-------------------------|
| A | 00.11.07 | NEW ISSUE               |
| B | 04.11.22 | ADD CUTOUTS & -043/-044 |



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SUBJECT TO AMENDMENT

- D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)** ENGINEERING  
UNCONTROLLED COPY

1) MACHINE PER DRAWING FILE "D2803.SLDPRT" SUBJECT TO AMENDMENT

2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 WITH ~~NO~~ NOTICE

3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES WORK ORDER NO. ~~444178~~

4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

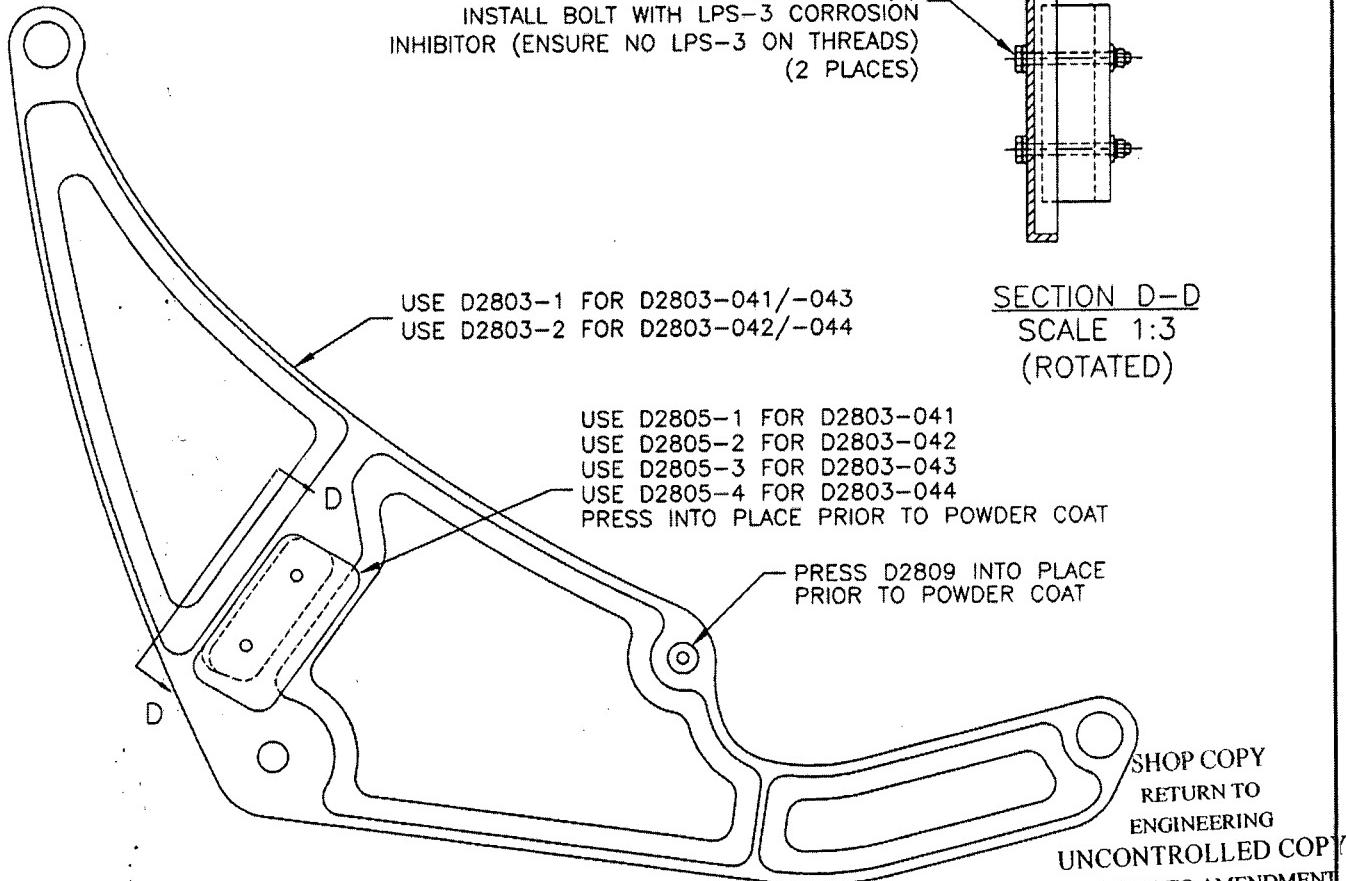
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>CP                  | DRAWN BY<br>CP                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2803                              | REV. B<br>SHEET 2 OF 2 |
| DATE<br>04.11.22              | TITLE<br>STA 84 BRACKET        | SCALE<br>1:3                                      |                        |



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WITHOUT NOTICE  
WORK ORDER

RELEASED NO. *114477*

*05-03-11* *[Signature]*

### D2803-041/-043 BRACKET ASS'Y (SHOWN)

### D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3